

Date: Thursday, 2/1/2007 2:50:07 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT ASSEMBLY
Job Number	: 30581		
Estimate Number	: 12695		
P.O. Number	: N/A	Part Number	: D2302
This Issue	: 2/1/2007 S.O. No. : N/A	Drawing Number	: D2303 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 3/15/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.02.01</u>		
Comment	: Est Rev: A New Issue 07-02-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2318	Heater Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Support

Batch: B3851=2 B30601=6

J.E. 07.03.07 4

2.0	D2285	Tube Locator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube Locator

Batch: B3853=4 B31090=4

J.E. 07.03.07 4

3.0	D2290	Heater Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube

Batch: B30597

J.E. 07.03.08 4

4.0	D2291	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 4"

Batch: B30598

J.E. 07.03.08 4

5.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 4"

Batch: B27216=3 B26912=1

J.E. 07.03.09 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/1/2007 2:50:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT ASSEMBLY

Job Number: 30581

Part Number: D2302

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2293

Heater Tube 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Heater Tube 6"

Batch: B30620

PE. 07.03.09

4

7.0

AN81816D

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: B2535

PE. 07.03.13

4

8.0

MS2081916D

Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Sleeve

Batch: B2535

PE. 07.03.13

4

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2302 USING DT 2302

A/R AL ROD

Batch: M100237

PE. 07.03.13

370

4

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07.03.15 (4)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07.03.15 (4)

12.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3336

RED Anodize weldment as per Dwg D2303

Ensure Certificate of Conformity is attached

C207103/16

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01-03-13	9	welded support plate on wrong side had to cut off and weld on good side. scrap 2 pcs 02388	<i>[Signature]</i> 02/03/13	cut of support plate and welded new support plate on proper side	02-03-13 <i>[Signature]</i> 07/03/13	<i>[Signature]</i> 07/03/13	<i>[Signature]</i> 07/03/13	

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: OUTLET WELDMENT ASSEMBLY

Job Number: 30581

Part Number: D2302

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

2/1/07 13.03 (4)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1207-03-27 (4)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

1207-03-27 (4)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1207-03-30

Job Completion



1207-03-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. E
CHECKED	APPROVED	D2302	SHEET 1 OF 2
BW	BW		
DATE	TITLE		
94.10.25	INTAKE WELDMENT ASSEMBLY		
D	JAN. 10, 1995	GENERAL REVISION	
E	96.01.26	REMOVED REV FROM PART LIST	

QTY	Part No.	Description
X	D2302	INTAKE WELDMENT ASSEMBLY
2	D2285	HEATER TUBE LOCATOR
1	D2290	1" HEATER TUBE
1	D2291-1	4" HEATER TUBE
1	D2292	4" HEATER TUBE
1	D2293	6" HEATER TUBE
1	D2318	END PLATE
1	AN818-16D	FLARE NUT
1	MS20819-16D	SLEEVE

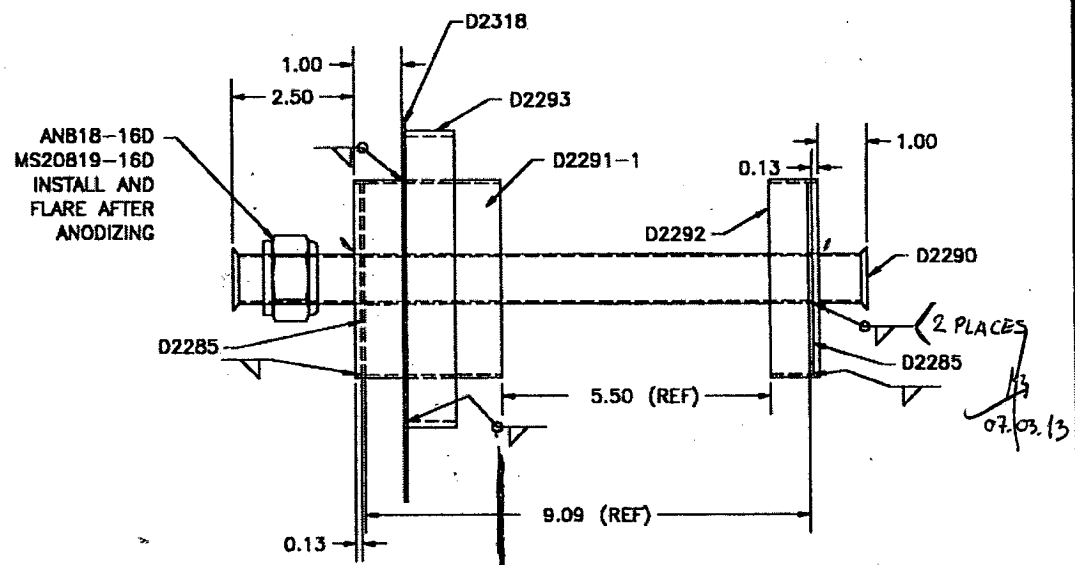
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30581

DART



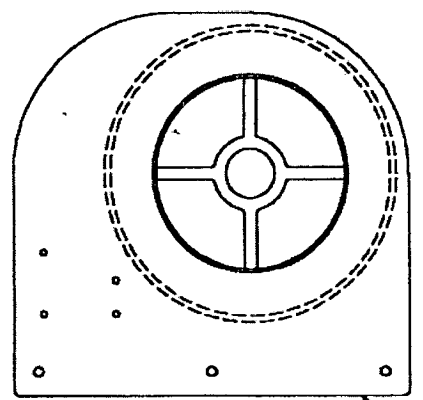
DESIGN	B WILLIAMS	DRAWN BY	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. E
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2302	SHEET 2 OF 2
DATE	94.10.25	TITLE	INTAKE WELDMENT ASSEMBLY	SCALE	

exhaustable



inside weld

FINISH: ANODIZE



D2318

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *30581*

TNM

ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**FACTURE
INVOICE****53941**

22-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE: 00003336****CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

QTY	QTY	QTY	DESCRIPTION	UNIT PRICE	AMOUNT
1	4	4	D2302	B30581	\$22.50
2	4	4	D2303	B30582	\$22.50
SUB TOTAL:					\$180.00
TPS/GST:					\$10.80
TVQ/PST:					\$0.00
TOTAL AMOUNT DUE:					\$190.80

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

**CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS**

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

